

**Amendment to the Specification:**

Please replace paragraph [0024] with the following amended paragraph:

[0024] Now that the various part of the quick change vice jaw have been described, the installation and removal of a quick change vice jaw can be considered. This description of the installation and removal of a quick change vice jaw will avoid plurals whenever possible. The reader should understand that this description relates to the installation of preferably two quick change vice jaws on opposed vice jaws and that vice jaws are preferably substantially identical and each preferably includes at least two retention recesses which are compatibly spaced to interface with at least two corresponding jaw plate retainers. It should also be understood that the jaw plate retainers may be threaded into at least two standard bolt holes 8A1 spaced apart by a standard distance and disposed in the opposing faces of the vice jaws. As noted above, jaw plate retainer 12 has an externally threading housing 14 and is adapted to mate with a typical threaded bores 8A1 of a vice jaws 5A shown in FIG. 2. Before a quick change jaw plates 50 can be mounted to vice jaw 5A or 5B, two jaw plate retainers 12 are threaded into bolt holes 8A1 such that each radial flange 14B is flush against the surface of vice jaw 5A.[.]

Please replace paragraph [0025] with the following amended paragraph:

[0025] Once, jaw plate retainers 12 are in place, it is possible to mount a jaw plate 50 to a vice jaw 5A. To understand the mounting of one jaw plate 50 it is best to consider the action of one retention recess 80 of a jaw plate 50 relative to one jaw plate retainer 12.[.] To mount jaw plate 50 to a vice jaw such as vice jaw 5A, the jaw plate 50 is mated with a vice jaw so that a retention recess 80 is placed over a jaw plate retainer 12 so that flange 14B of jaw plate retainer 12 is received by recessed face 81 and such that head 28C of retention pin 26 is received by wide portion 82 of retention recess 80. Jaw plate 50 is tapped with a mallet from the opposite direction of wide portion 82 (in the direction shown by arrow 51 in FIG. 7) so that the ramped shoulders 84A and 84B of narrow portion 84 of recess 80 engage and pull against surface 28C of retention pin 26 to cause retention pin 26 to pull away from housing 14 of retainer 12. Head portion 28 of retention pin 26 slides up ramped shoulders 84A and 84B until head portion 28B is captured by detent portion 86 of recess 80. This motion is indicated by arrow 61 and the jaw plate retainer positions indicated by 12 and 12' in FIG. 7. At this point, when two retention pins 26 are located so that they are captured by respective, compatibly spaced detent portions 86, jaw plate 50 is retained against movement in the plane of the vice jaw face. If two opposite jaw plates which are retained in this manner are pressed together to hold a workpiece, their respective positions will be accurate and repeatable. Accordingly, if two opposite jaw plates are machined with special features for holding a particular workpiece, then the workpiece may be located

relative to a machine in an accurate, repeatable manner thus eliminating the step of determining the position of the work piece in relation to the machine and thus reducing set up time as various jaw plates are interchanged between various machining tasks.

Please replace paragraph [0026] with the following amended paragraph:

[0026] As can be seen from the above description of the installation of a quick change jaw plate 50, it is only necessary to position jaw plates 50 accurately and repeatably until vice jaws 5A and 5B apply a significant amount normal pressure which acts to hold the quick jaw plates 50 in a fixed position. When the pressure of vice jaws 5A and 5B is released, a jaw plate 50 can be removed with little effort. Accordingly, an operator can quickly remove a jaw plate 50 from a vice jaw such as vice jaw 5A with an action that is the reverse of the one described above. Namely, an operator may tap upon jaw plate 50 from the end opposite detent portions 86. This tapping on jaw plate 50 causes the head ~~portion 28~~ portions 28 of each retainer pin 26 to pop back up into the slot portion 84 of each retention recess 80. As the operator continues to tap or push on jaw plate 50, the head portions 28 of each retainer pin 26 proceed down the ramped shoulders 84A and 84B of each narrow portion 84 until head portions 28 align with the wide portions 82 of each retention recess 80. At this point, the operator may pull jaw plate 50 away from vice jaw 5A.